

Date: Monday, 11/6/2006 2:40:46 PM
User: Kim Johnston

Process Sheet

split -

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 29357
Estimate Number : 10428
P.O. Number : *NIA*
This Issue : 11/6/2006 S.O. No. : *NIA*
Prsht Rev. : NC
First Issue : 11/6/2006 Type : MACHINED PARTS
Previous Run : 28272
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est A 04.04.19 New issue KJ/JLM

Drawing Name : MOUNTING LUG
Part Number : D32351
Drawing Number : D3235 REV A
Project Number : N/A
Drawing Revision : A
Material : *NIA*
Due Date : 11/22/2006

Qty: 100 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 7.1715 f(s)

Lug Extrusion

D2423 extrusion

Batch: *B 23779*

J.F. 06/11/07

(101)

2.0 BAND SAW BAND SAW



Comment: Band Saw

Cut D2423 extrusion to 0.820"

Batch: *B 23779*

J.F. 06/11/07

(101)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA369 and Dwg D3235

2-Identify as D3235-1

3-Deburr and Tumble

Issue P.O. 243804/11/05

101

Machine per dwg D3235 Rev. A

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Receive + Inspect for transit

damage PU 9/11/2 (91)

5.0 QCS SECOND CHECK



Comment: SECOND CHECK

Inspect Level 5

[Signature] 02-01-07 QSPOR

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ml/yl 07-01-02

(91)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-01-03

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

FL/a.m 07/01/04 (91)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/01/05

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5194*

07/01/05 (91) 07/01/05

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/08 (91)

Job Completion

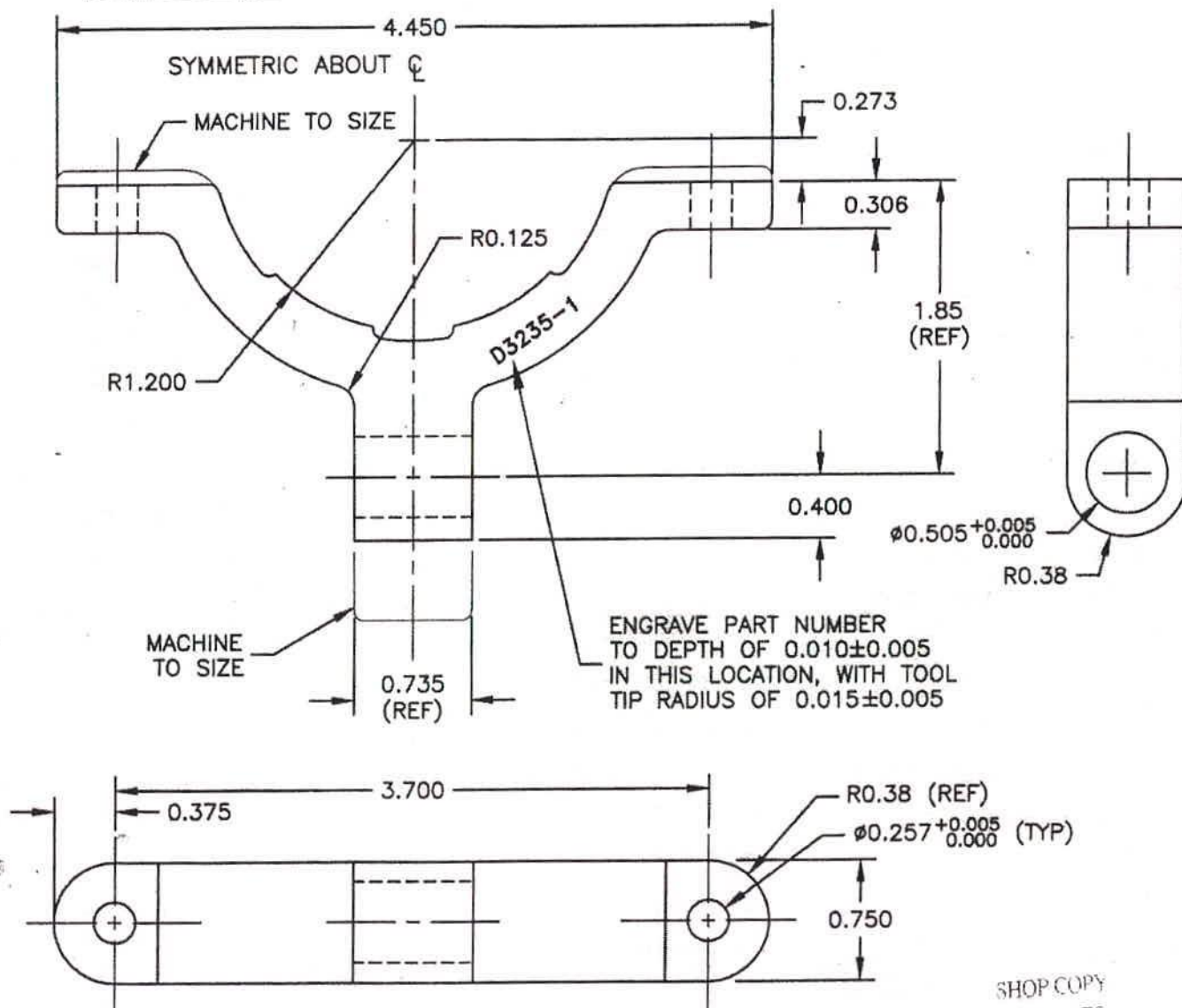


07-06-08



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
04.04.05



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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WORK ORDER
NO. 29357

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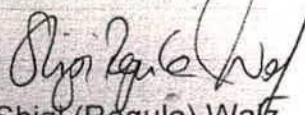
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
91	D3235-1	Lug B29357 ✓	2438

MATERIAL: supplied by DART D2423 B23779

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, January 2, 2007

